May-22-13 1:30:39 PM

Item ID: D2013-4 Accept *N900040100* Setup Start Revision ID: Item Name: Mirror Bracket RH, 212 Start Date: 5/22/13 Start Qty: 6.00 Cust Item 1D: Required Date: 6/05/13 Req'd Qty: 6.00 Customer: Reference: Run Start Process Plan: MLJ Approvals Date: \3-05-22 Tooling: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Accept Reject Tool # Plan Insp. Reject Work Center ID Description Run Hours Code Oty Qty Number Stamp Draw Nbr **Revision Nbr** . D2013 Rev C 13/07/24 F13-08-20 100 0.00 NC BRAKE *1በበ* Brake NC 0.00 Memo Brake NC . 1-Punch as per template D2013-T3 and Dwg D2013 2-Flatten ends of D2013-3 tube as per Dwg D2013 using DT8545 3-Bend (1) tube as per Dwg D2013 using Jig DT8201 Identify as D2013-3. 4-Deburr as required 110 QC5- Inspect part completeness to step on W/O 0.00 *110* QC Memo Quality Control

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NCR: \	/es	/ No				WORK ORDER NON-C	COF	NFORI	MANCE / UP	DATE	QA Closed:	Date	• •
Work Orde	eŕ:	; -				DISPOSITION		_		AGAINST DE	PARTMENT,	/PROCESS	
Part N	- ۱۵۰					Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		nitial		tion	Sign &	· · ·	
Cause	1	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
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1		Bending				Bend		Grain			Ovalized		Pressure/Forced
	-	Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	ire		Over/Under	tolerance	Temperature/Cure
	П	Cracks				Broken/Damaged ,		Inspect	ion Incomplete		Part Incorre	ct	Weld
		Crushed/	Crimped			Burrs		Instruct	tions Incomplete/	Unclear	Part Lost/Mi	issing	Wrong Stock Pulled
l.		Cuffs				Contamination		Mainte	enance		Part Moved		_
		Heat Trea	it			Countersink	ø	Mislabe	eled		Positioned V	Vrong	-
		Inspection	n Strip in	Tube		Cut Too Short		Misread	d		Power Loss/	Surge	Other
		Ripples in	Bend			Drill Holes	3	Offset					
		Torque W	aves in E	extrusio	n	Drawing 🔓	_	1	Calibration				
		Turning S	equence			Finish		Out of :	Sequence			<u></u>	

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

QC

Quality Control

May-22-13 1:30:39 PM Item 1D: 122013-4 Accept *N900040100* Setup Start Revision ID: Item Name: Mirror Bracket RH, 212 Start Date: 5/22/13 Start Oty: 6.00 Cust Item ID: Required Date: 6/05/13 Req'd Qty: 6.00 Customer: Reference: Run Process Plan: ____ Date: ____ Tooling: Approvals: _ _ _ _ Date: _ _ _ SPC (Y/N): ___ _ Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description Run Hours Code Qty Number Stamp Qty 120 Identify as per dwg & Stock Location: W/ cor1 0.00 *120* 6 9 13-8-20 Packaging 0.00 Memo Packaging 130 QC21- Final Inspection - Work Order Release 0.00 *130*

0.00

Memo

MLJ 13-08-26

												DQA:	Da	ate:	
NCR:	/es	/ No				WORK ORDER NON-O	100	NFORM	MANCE / UP	PDATE		•			
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				_	;	DISPOSITION	-			AGAINST DI	EP	PARTMENT	PROCESS		
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Landi	_	Bending				Bend		Grain		Г	٦	Ovalized			Pressure/Forced
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		Heat Trea	at		<u> </u>	Countersink	-	Mislabe		 	-	Positioned W	/rong		
		Inspectio		Tube	<u> </u>	Cut Too Short		Misread		F	-1	Power Loss/	-		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

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Work Order ID: 102022

D2013-4 Parent Item:

Parent Item Name: Mirror Bracket RH, 212

102022 *D2013-4*

Start Date: 5/22/13

Required Date: 6/05/13

Start Qty: 6.00

Required Qty: 6.00

IPP Rev:A Comments: New Issue 05-11-01 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			100	f	516.7703	1.9473	12.29874			- - · ·
M304TR0		N49							**		·	Si	(3 (97/04

Location	Loc Oty	Loc Code	
MAT017	516.7702825		
122312	13.3		
122468	0.0000325		
124768	86.93245		
·-125068	127.5378		_/5
125513	· 289		

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_ - -												QA Closed:	Da	te:	
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WOIR Old					· · · · · · · · · · · · · · · · · · ·	Rework	1	İ	Skid-tube	Crosstube	٦		Water Jet	Г	Engineering
Part I	do.					Scrap	┨		Machining	Small Fab	1	Pro	d. Eng. Coor.	一	Quality
laiti	•••					Use-as-is	1		noforming	Finishing	┪		e/Packaging	一	Other
NCR I	No.					Work Order Update	1		Large Fab	Composite	٦		Supplier	_	1
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Root				ļ	Descri	ption of work order update		Initial	Act	tion	T	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Cr	nief Eng	Desci	ription	\perp	Date	Verificatio	<u>n</u>	QC Inspector
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Landi	$\overline{}$				_	General	_	7		_	_			_	ז
	\vdash	Bending			<u> </u>	Bend		Grain		<u> </u>	-1	Ovalized		L	Pressure/Forced
	Ш	Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa		Ĺ	-	Over/Under		\vdash	Temperature/Cure
	Ш	Cracks				Broken/Damaged	\perp	⊣ `	on Incomplete	<u> </u>		Part Incorred		L	Weld
		Crushed/	Crimped			Burrs	\perp	-1	ions Incomplete/I	Unclear	_	Part Lost/Mi	ssing	L	Wrong Stock Pulled
		Cuffs				Contamination	_	Mainte		Ļ	-	Part Moved			
		Heat Trea	ət		<u></u>	Countersink	_	Mislabe		L	_	Positioned V	_	_	•
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	d			Power Loss/S	Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

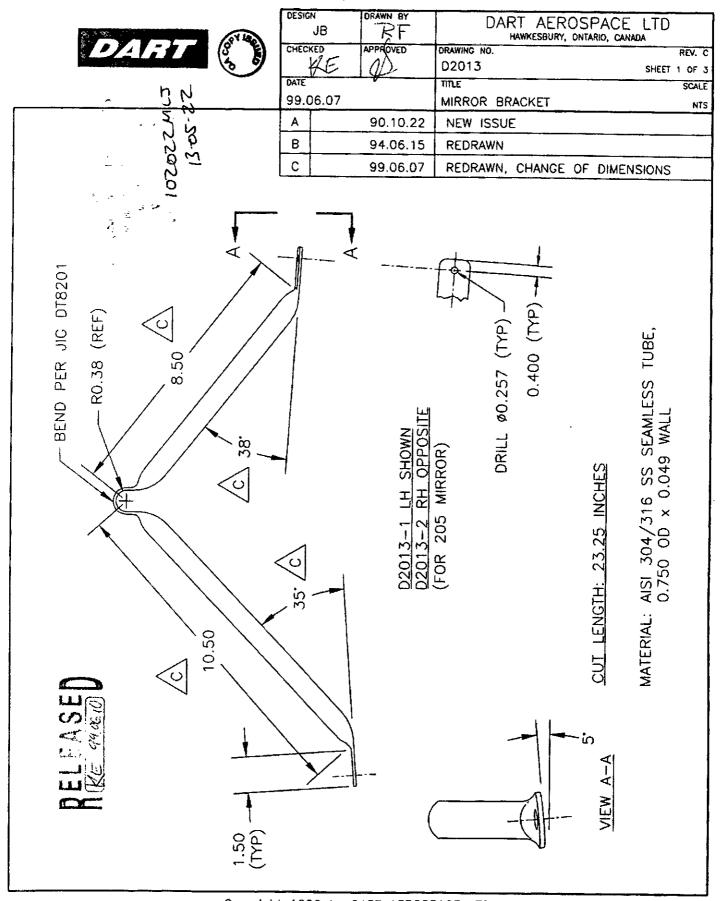
Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

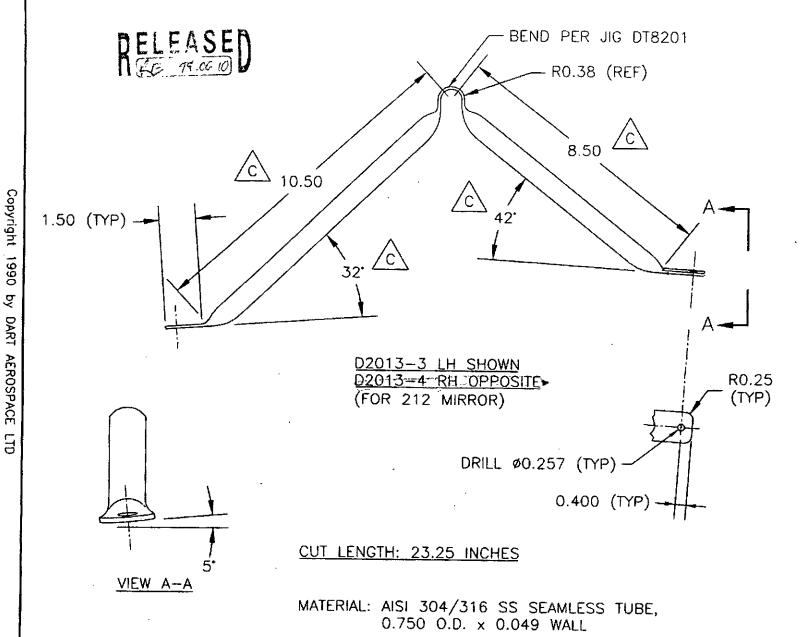


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99.06.07 MIRROR BRACKET DRAWING NO. D2013 SHEET 2 OF 3

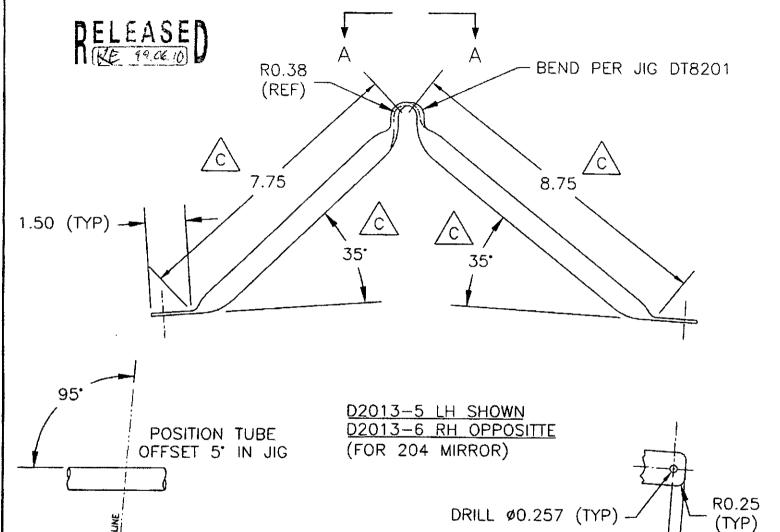


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MIRROR BRACKET		99.06.07
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D2013 SHEE	*	AR
DRAWING NO.	APPROVED	CHECKED
HAWKESBURY, ONTARIO, CANADA	RH	Bľ
DART AFROSPACE ITC	DRAWN BY	DESIGN



CUT LENGTH: 20.75 INCHES

Copyright 1990 by DART AEROSPACE LTD

VIEW A-A

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,

0.750 O.D. x 0.049 WALL

0.400 (TYP)

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